

Date: Friday, 2/23/2007 8:32:14 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 30896		
Estimate Number	: 10494		
P.O. Number	: <i>N/A</i>	Part Number	: D32045
This Issue	: 2/23/2007	Drawing Number	: D3204 REV. A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i>	Drawing Revision	: A1
Previous Run	:	Material	: <i>N/A</i>
	Type : MACHINED PARTS	Due Date	: 3/21/2007
Written By	:	Qty:	8 Um: Each
Checked & Approved By	: <i>07.02.23</i>		
Comment	: Est:C 05.08.11 Added Step 25 KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0375X01250	6061-T6 Bar .375 x 1.25"
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Comment: Qty.: 0.3059 f(s)/Unit Total : 2.4469 f(s)

Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8)

(M6061T6B0.375x01.250)

Batch: *M103755* *07/03/19*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank: 1.25" x 0.375" x 3.370" long Bar (+0.030/-0.000)

*07/03/19*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA344 and Dwg D3204

2- Deburr

Identify as D3204-5

*SD 07.03.20**(P40)*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SD 07.03.20*

5.0	QC8	SECOND CHECK
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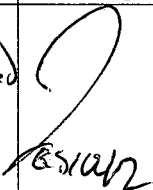
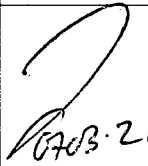
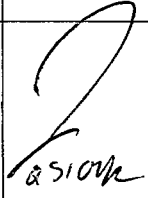



Comment: SECOND CHECK

*SD 07/03/21*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/03/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070320	3.0	- tips of endmill chipped thus counter bore is undersized - 4 parts		- change endmill - reduce feed rate scraper replace	SA 070321	 0703-21	 0703-21	 0703-21

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 30896

Part Number: D32045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*02/3/21*

*(8)*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



*(8)*

Comment: FINAL INSPECTION/W/O RELEASE

*07/03/23*

Job Completion



*U 07-03-22*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

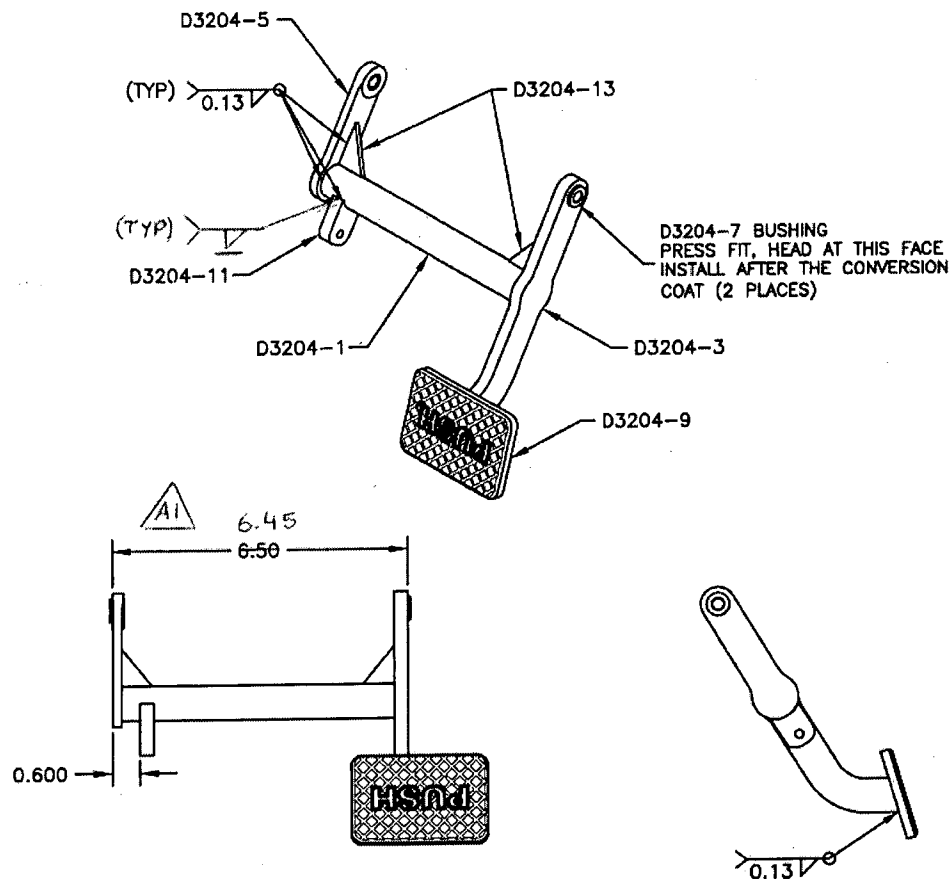
NOTE: Date & initial all entries





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CHECKED #	APPROVED #	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED  
04.04.30



### D3204-041 RELEASE PEDAL ASSEMBLY

#### NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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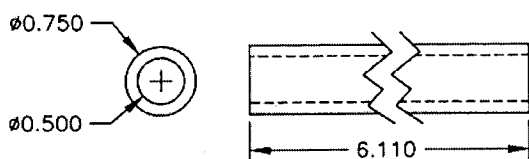
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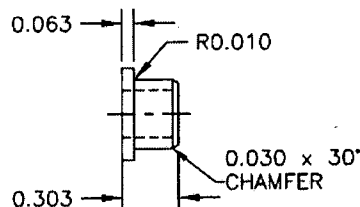


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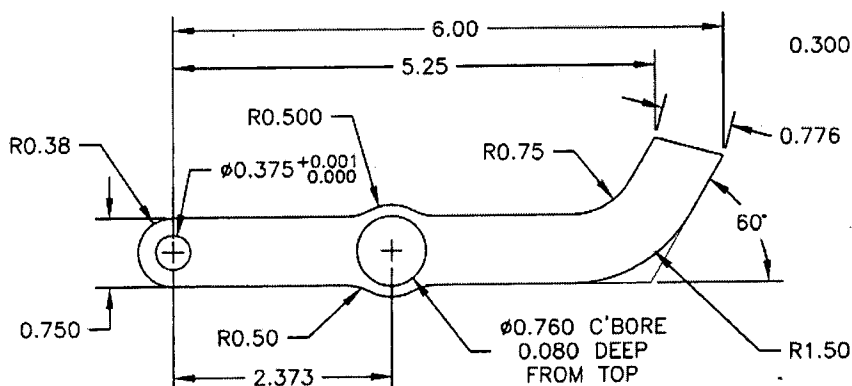
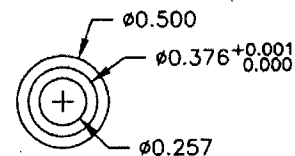
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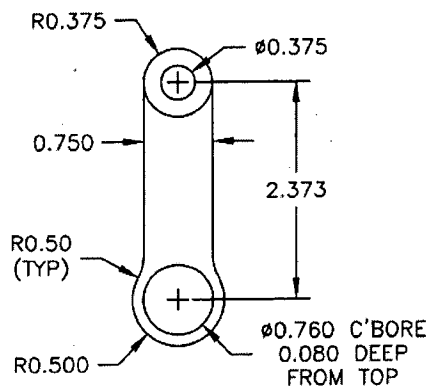
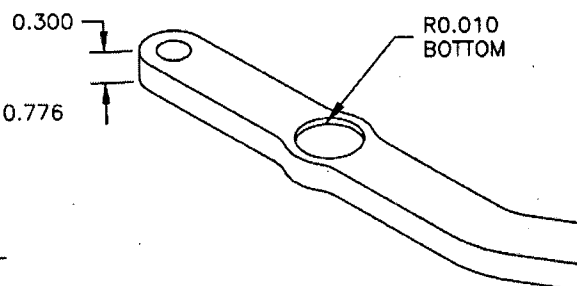
2 D3204-1 TUBE  
SCALE 1:2



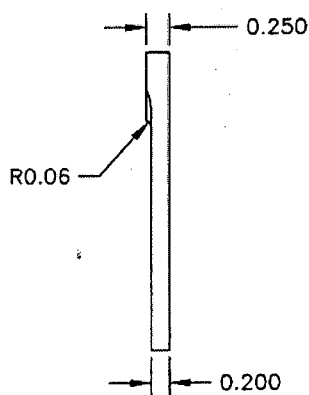
4 D3204-7 BUSHING  
SCALE 1:1



3 D3204-3 ARM  
SCALE 1:2



3 D3204-5 ARM  
SCALE 1:2



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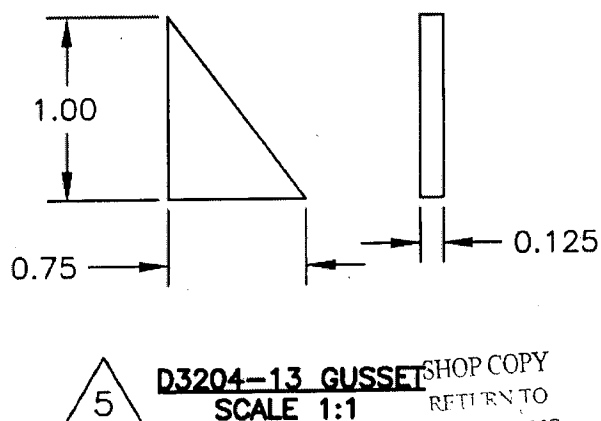
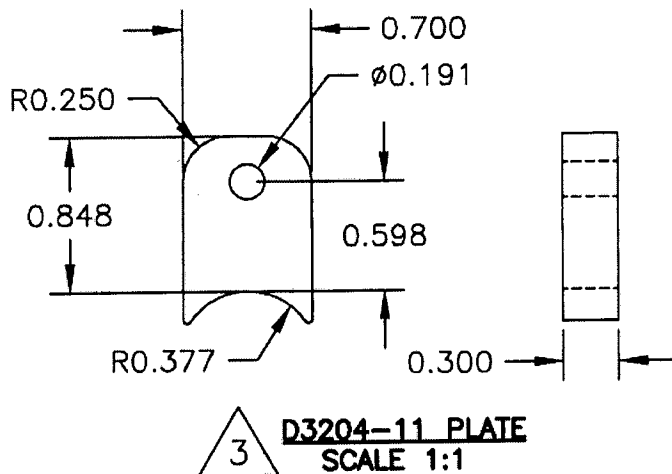
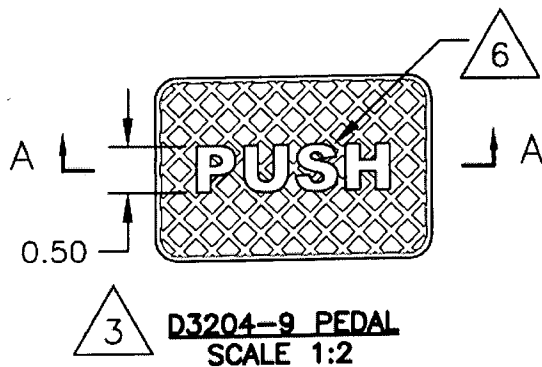
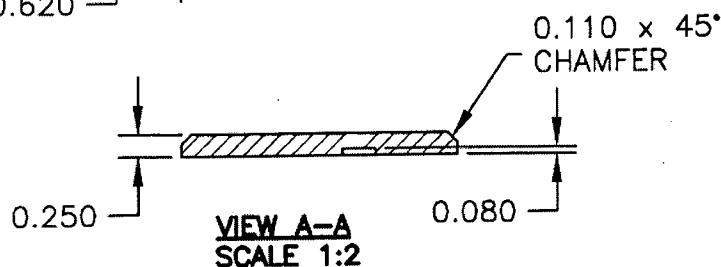
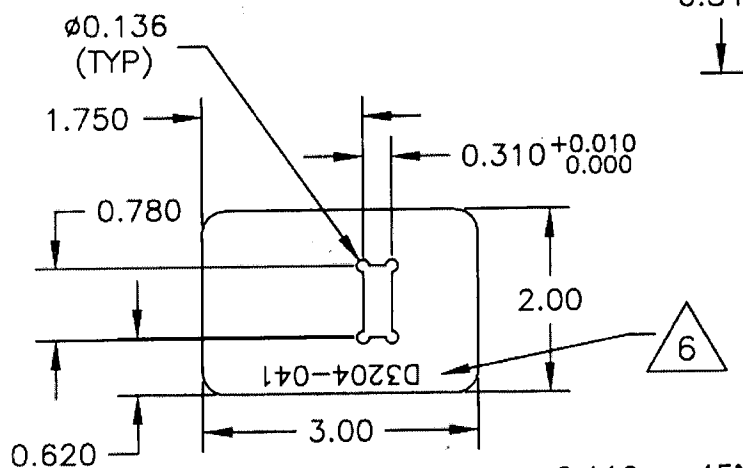
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